

Wednesday, 07/01/2009 10:03:14 AM

User:

Julie Dawson

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D412-630-034	<i>Rush</i>
Job Number	: 44423	Part Number	: REWORK15	
Estimate Number	: 10804	Drawing Number	: NCR08-125	
P.O. Number	:	Project Number	:	
This Issue	: 07/01/2009 S.O. No. :	Drawing Revision	:	
Prsht Rev.	: NC	Material	:	
First Issue	: // Type : LARGE FAB ASSY	Due Date	: 14/01/2009	Qty: 1 Unit Each
Previous Run	: 00015			
Written By	:			
Checked & Approved By	: <i>JUD 09.01.07</i>			
Comment	:			

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D412630034

Heli Access Step RH Folding



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Heli Access Step RH Folding

Pull from stock:

Qty 1

B44084

SB 09/01/07

2.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Disassemble and remove the D2804-042 bracket and scrap per NCR08-125, as it is the Rev.B style.

Keep all necessary hardware for re-assembly.

Pick the following for re-assemble:

EB 09/01/07 @
collar pin M524665-302 B M 104263 8/09/01/07

3.0

D2804042

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Bracket Assembly

Ensure it is a Rev.C bracket

B *1344272**SB 09/01/07*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D412-630-034

Job Number: 44423

Part Number: REWORK15

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8/09/01/07 (41)

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Re-package the step, keeping the same batch #.
Ensure original kit is included

Return to stock.

Location:

Rev A 10 8/01/07 (1)

6.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

8/09/01/07 (41)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10/09/01/07 (1)

Job Completion



u 09.01.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

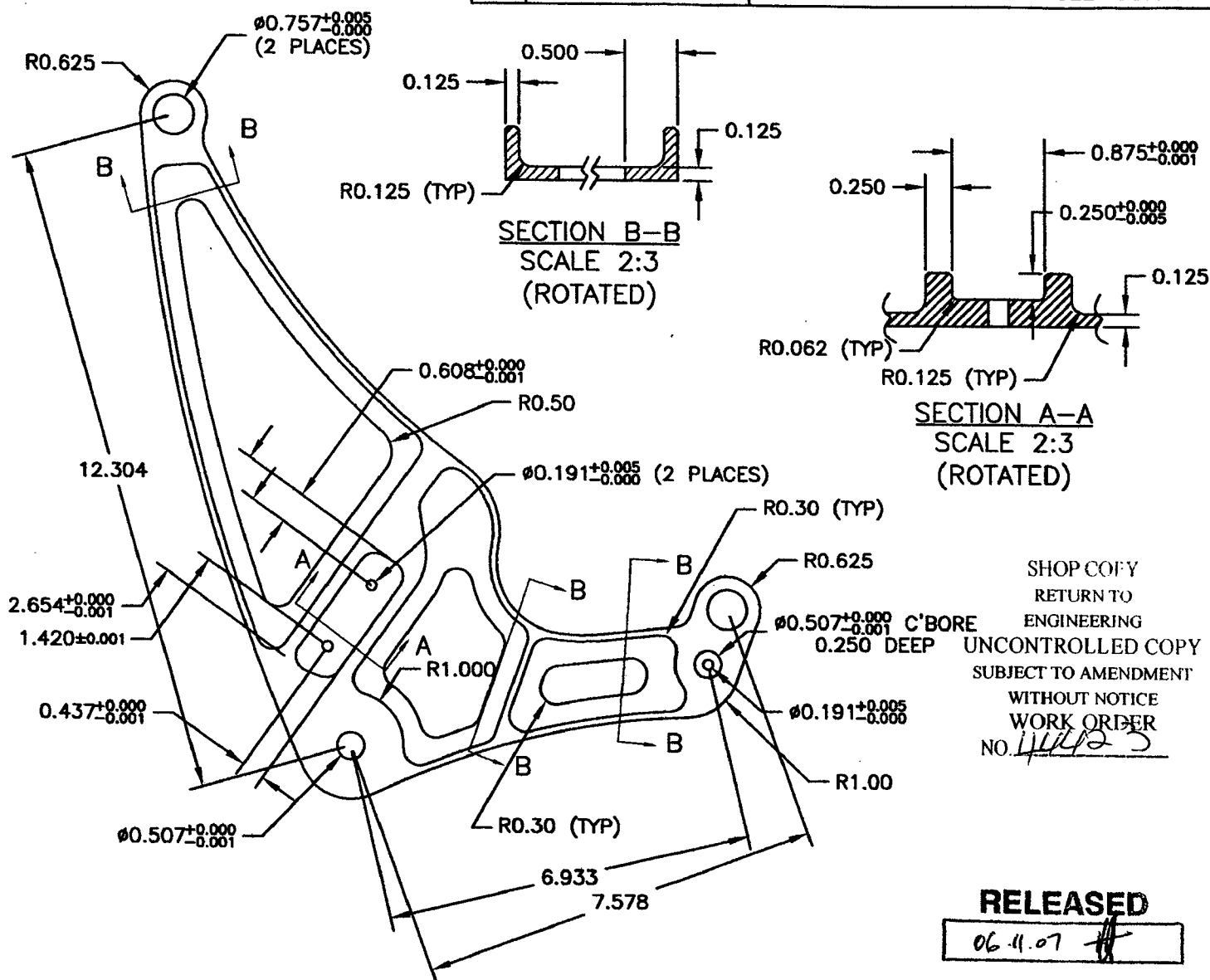
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2804	REV. C SHEET 1 OF 2
DATE 06.10.16	TITLE STA 155 BRACKET		SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	
C	06.10.16	CHANGE GEOM. TO ADD CLEARANCE	

REFERENCE ONLY

**D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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